

**DEPARTMENT OF TRANSPORTATION****DIVISION OF ENGINEERING SERVICES**

Office of Structural Materials

Quality Assurance and Source Inspection



Bay Area Branch  
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Contract #: 04-0120F4Cty: SF/ALA Rte: 80 PM: 13.2/13.9File #: 69.28**WELDING INSPECTION REPORT****Resident Engineer:** Pursell, Gary**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-001484**Date Inspected:** 17-Feb-2008**Project Name:** SAS Superstructure**OSM Arrival Time:** 600**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 1530**Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **Location:** Shanghai, China**CWI Name:** Cui Yi Ru**CWI Present:** Yes No**Inspected CWI report:** Yes No N/A**Rod Oven in Use:** Yes No N/A**Electrode to specification:** Yes No N/A**Weld Procedures Followed:** Yes No N/A**Qualified Welders:** Yes No N/A**Verified Joint Fit-up:** Yes No N/A**Approved Drawings:** Yes No N/A**Approved WPS:** Yes No N/A**Delayed / Cancelled:** Yes No N/A**Bridge No:** 34-0006**Component:** OBG**Summary of Items Observed:**

Caltrans Quality Assurance (QA) Inspector Tim McClendon arrived on site at the Zhenhua Port Machinery Company (ZPMC) facility at Changxing Island, in Shanghai, China to periodically monitor welding and Quality Control (QC) functions. While on site the QA Inspector observed and/or discovered the following.

Caltrans QA Inspector observed ZPMC welder, Hong Shuili, certification number 044815 depositing filler metal, on a Complete Joint Penetration (CJP) repair, weld number 043, using the Flux Cored Arc Welding (FCAW) process, with the guidelines of Welding Procedure Specification (WPS) WPS-345-FCAW-2-G-FCM-Repair, on floor beam sections for OBG. The related drawing number is FB8. The QA Inspector also witnessed ZPMC Certified Welding Inspector (CWI), Cui Yi Ru Certification Number 00072221, monitoring all related welding activities and ZPMC Quality Control (QC) Inspector, Zhu Tiam Shu, monitoring and recording related welding parameters. In addition QA inspectors randomly monitored welding activities and also recorded related welding parameters. His findings are as follows, amps 280, volts 28, and a travel speed of 504mm per minute. It appears to this QA inspector all related welding activities comply with applicable codes, standards and specifications.

**Summary of Conversations:**

No relevant conversations spoken on this date.

**Comments**

This report is for the purpose of determining conformance with the contract documents and is not for the purpose of making repair or fit for purpose recommendations. Should you require recommendations concerning repairs or remedial efforts please contact Mazen Wahbeh, (818) 292-0659, who represents the Office of Structural Materials

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## WELDING INSPECTION REPORT

( Continued Page 2 of 2 )

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for your project.

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**Inspected By:** McClendon,Timothy

Quality Assurance Inspector

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**Reviewed By:** Cuellar,Robert

QA Reviewer